

Work Order ID 60225

Tuesday, June 29, 2010 11:39:03 AM



Page 1

Item ID: D2739

Revision ID:

Item Name: 350 I Beam

Start Date: 6/29/2010 Start Qty: 4.00

Required Date: 7/6/2010 Req'd Qty: 4.00

Reference:

Accept



Setup

Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 6-29

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2739

Rev D

100



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

- 1-Cut D2600-5 to length as per Dwg D2739.
- 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
- 3-Use uni-bit to open holes to finish size as per Dwg D2739.
- 4-Bevel Fwd end of extrusion and Deburr holes and ends.
- 5-Dburr

Q.m 10 - 07 - 05 (4)

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Q.m 10 - 07 - 05 (11)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Page 2

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Run

Start



Stop



Sequence ID/
Work Center ID

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Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/6/2106

84

140



Packaging

Packaging

Identify as per dwg & Stock Location: L.B.

Memo

0.00

0.00

4

11/6/7/6

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

100707
MFC
10-7-6

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 29, 2010 11:39:07 AM

Page 1

Work Order ID: 60225

Parent Item: D2739

Parent Item Name: 350 I Beam



Start Date: 6/29/2010

Start Qty: 4.00

Required Date: 7/6/2010

Required Qty: 4.00

Comments:

IPP Rev: C 02.11.28 Reformat KJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2600-5-108 | | Manufactured | No | | | 100 | Each | 176.0000 | 1 | 4 | | | |

Extrusion 'I Beam' thin



Q.m - 10-07.06

Location

LG

47814

Loc Qty

176

176

Loc Code

4

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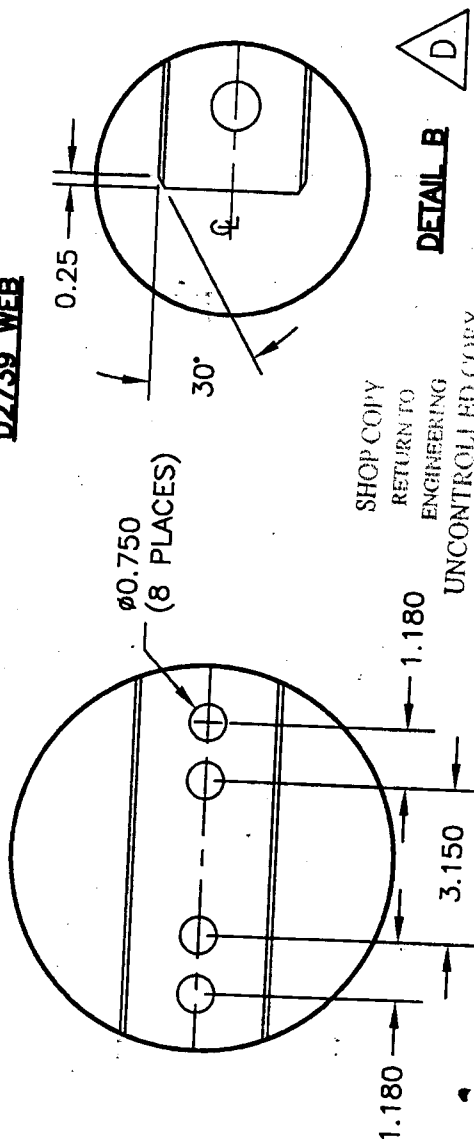
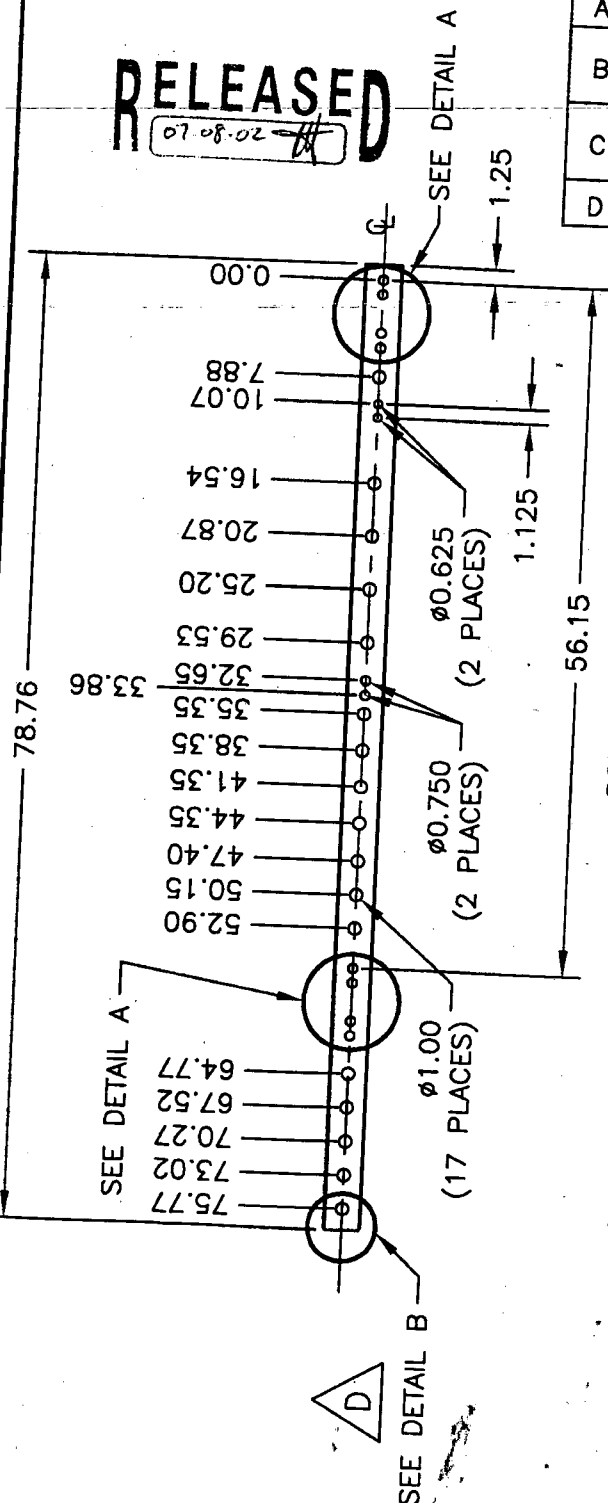
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NOTE: Date & initial all entries

DART**RELEASED**
07-08-02

| | | | |
|-------------------------|-----------------------|---|--|
| DESIGN PH | DRAWN BY CB | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED PH | APPROVED HA | DRAWING NO. D2739 | REV. D SHEET 1 OF 1 |
| DATE 07.05.29 | TITLE WEB | | |
| A | | 98.04.16 | NEW ISSUE |
| B | | 98.11.18 | CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS |
| C | | 06.01.05 | ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS |
| D | | 07.05.29 | ADD BEVEL TO FWD END; ADD DETAIL B |



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 00205

- NOTES:
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) PART IS SYMMETRIC ABOUT C

| W/O: | | WORK ORDER CHANGES | | | | | |
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